

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013528**Date Inspected:** 08-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Liang Zhu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

Tower Trial Assembly**MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY SOUTH TOWER LIFT-1**

This QA Inspector carried out the measurements on South Tower Lift-1 Exterior side to check the distance from the edge of the base plate anchor bolt holes to the side of the bearing, type-1 & 2 stiffeners and the distance from one bearing stiffener to the other for skin 'D'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

MEASUREMENTS OF GAP BETWEEN TOWER STRUT AND TOWER DIAPHRAGM

This QA Inspector carried out the measurements on Tower Strut Plate to Tower Diaphragm gap at top and bottom sides. The measurements were taken at 53Metre, 65Metre and 77Metre elevations of erected tower lift-2. Measurements were recorded on the data sheet and submitted to the assigned task leader. The members are identified as Tower Components. The members designation reviewed are as follows:-

53 Metre Elevation

1. WD1-A305-53M-1
2. WD1-A305-53M-2

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

3. WD1-A305-53M-3
4. WD1-A305-53M-4
5. ND1-A476-53M-1
6. ND1-A476-53M-2

65 Metre Elevation

1. WD1-A305-65M-1
2. WD1-A305-65M-2
3. WD1-A305-65M-3
4. WD1-A305-65M-4
5. ND1-A476-65M-1
6. ND1-A476-65M-2

77 Metre Elevation

1. WD1-A305-77M-1
2. WD1-A305-77M-2
3. WD1-A305-77M-3
4. WD1-A305-77M-4
5. ND1-A476-77M-1
6. ND1-A476-77M-2

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 053 located on East Tower Lift-1 outside bearing stiffener Plate ESD1 – SA227F/H. Welder is identified as 203269. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

(See attached photo)

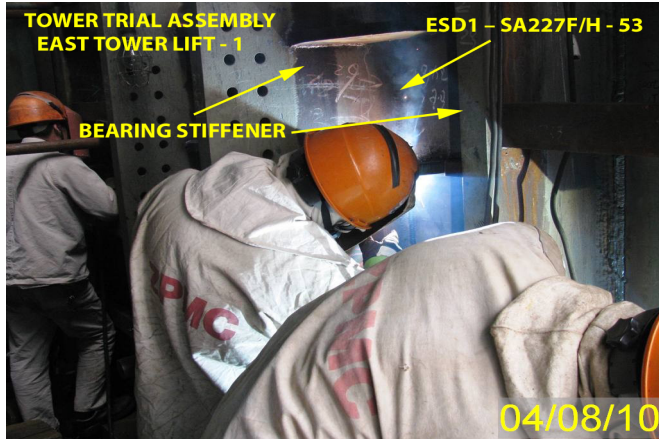
Weld joint # 045 located on South Tower Lift-1 outside bearing stiffener Plate SSD1 – SA16F/G. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 027 located on East Tower Lift-1 outside bearing stiffener Plate ESD1 – SA227F/H. Welder is identified as 049541. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
